

Work Order ID 57882

Monday, April 19, 2010 3:33:53 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Item Name: Aft Door Assembly

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/4/20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

8/2/07/05

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11710

Description: D2445 Baggage Door

Supplier: Delastek

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

CL 10-4-20

U

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-588-041

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Revision ID:

Stop



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Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

4/19/10 3:30 (L)

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.
Audit process sheet.

5/10/06/30

(H)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

RT

10-06-30

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/07/01

(X)

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-7-15

160

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 10/07/05

(X)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 430.00 Revd

Packaging

Memo

0.00

Packaging

Rev 10/7/06

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/7/06
10-7-06

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57882

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN526C832R9		Purchased	No			140	Each	418.0000	8.0000			
Screw												
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST327</div> <div>113845</div> <div>114341</div> <div>114405</div> <div>418</div> <div>18</div> <div>200</div> <div>200</div> </div>												
AN960JD10	NA51149003635	Purchased	No			140	Each	0.0000	2.0000			
Washer												
AN960JD8	NA51149008325	Purchased	No			140	Each	0.0000	8.0000			
Washer												
D2143		Manufactured	No			140	Each	35.0000	1.0000			
Hinge Bracket												
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST198</div> <div>37739</div> <div>55323</div> <div>35</div> <div>9</div> <div>26</div> </div>												

ST 10-06-30

x8

ST 10-06-30

ST 10-06-30

ST 10-06-30

x1

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 4/19/2010

Required Date: 4/26/2010

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10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2144		Manufactured	No			140	Each	60.0000	1.0000			
											10-06-30	
Hinge Bracket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST198	60	
55061	8	
55179	52	

D2463		Manufactured	No			140	f	512.5036	7.2500			
											10-06-30	
Seal												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST404	512.5036	
43841	3	
50075	15.7536	
55561	493.75	

(D2463-0870) cut (1) at 7.25"
**** per kit****

*1 x 7.25

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P ☐ 04.02.04 ☐ Reformat ☐ KJ/DS ☐
per DS19414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2585		Manufactured	No			140	Each	107.0000	2.0000			
Mounting Channel												

B59118 x1



RT

10-06-30

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST018

62

53798

2

55313

60

Main Warehouse

ST019

45

56524

45

D2586

Manufactured No

140

Each

85.0000

2.0000



Door Latch

B57917 x2



RT

10-06-30

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST204

85

55314

85

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W/O:			WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2621		Manufactured	No			140	Each	118.0000	2.0000			
										PT	1006-30	
Latch Plate, 350 Spacepod												
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST021</div> <div>46842</div> <div>56526</div> </div> <div> <div>Loc Qty</div> <div>118</div> <div>49</div> <div>69</div> </div> <div> <div>Loc Code</div> </div>												
D2857-1		Manufactured	No			140	Each	38.0000	1.0000			
										XT	10-06-30	
Hinge Bracket												
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST026</div> <div>55019</div> <div>56529</div> </div> <div> <div>Loc Qty</div> <div>38</div> <div>19</div> <div>19</div> </div> <div> <div>Loc Code</div> </div>												
D2857-2		Manufactured	No			140	Each	48.0000	1.0000			
										PT	10-06-30	
Hinge Bracket												
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST027</div> <div>55020</div> <div>56530</div> </div> <div> <div>Loc Qty</div> <div>48</div> <div>28</div> <div>20</div> </div> <div> <div>Loc Code</div> </div>												

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist.Print

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Work Order ID: 57882



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P 04.02.04 Reformat KJ/DS
per DS19414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			140	Each	667.0000	8.0000			
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300 400

114330 400

Main Warehouse

ST301 267

114056 67

114227 200

MS21042L3

Purchased

No

140

Each

1,131.000 2.0000



Nut

w 114523 x 2

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300 1131

113537 147

113644 984

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Required Date: 4/26/2010

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per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-1-15		Purchased	No			140	Each	137.0000	2.0000			
Screw											BT 10-06-30	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST292	137	
112794	37	
114056	100	

AN526C1032R7

x2

Purchased

No



Screw

155

Each

136.0000

2.0000



10-7-18

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST328	136	
113064	66	
113749	20	
114056	50	

AN526C832R8

x1

Purchased

No



Screw

155

Each

140.0000

8.0000



10-7-18

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST327	140	
113595	140	

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10	NAS1149003621	Purchased	No			155	Each	0.0000	2.0000			
Washer												
AN960JD8	NAS149008321	Purchased	No			155	Each	0.0000	16.0000			
Washer												
D2150		Manufactured	No			155	Each	70.0000	2.0000			
Packer Doubler, Hinge												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST007 70
55016 16
55178 54

D2151		Manufactured	No			155	Each	55.0000	2.0000			
Packer Doubler, Hinge												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST007 55
51407 17
55319 38

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W/O:			WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Comments: IPP P 04.02.04 Reformat KJ/DS
per DS19414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2153		Manufactured	No			155	Each	36.0000	1.0000			
											10-7-1	SL
Door Prop												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST272	36	
48373	1	
55324	35	

D2154		Manufactured	No			155	Each	28.0000	1.0000			
											10-7-1	SL
Stud Bracket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST007	28	
44890	8	
55325	20	

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2237		Manufactured	No			155	Each	95.0000	2.0000			
Striker Plate											B58101	10-7-18

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST009 40

57255 40

Main Warehouse

ST010 55

55006 6

55312 49

D2461

Manufactured No

155

f

393.5000

7.2500



Neoprene "D" Seal



10-7-18

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST402 393.5

39782 6.5

55054 387

D2589

Manufactured No

155

Each

0.0000

1.0000



Keys, Key Chain, 350 Hinge



B58194 10-7-18

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2690-17		Manufactured	No			155	Each	8.0000	1.0000			
Cable												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

8

56567

8

D2858-1

Manufactured No

155

Each

40.0000

1.0000



Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

40

45798

7

55062

12

56423

21

D2858-2

Manufactured No

155

Each

32.0000

1.0000



Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST027

32

55063

11

56048

21

Monday, April 19, 2010 3:33:53 PM

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:33:53 PM

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Work Order ID: 57882

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Start Qty: 1.00

Required Date: 4/26/2010

Required Qty: 1.00

Component Item ID/ FG-778150-550-ROL	Replacement	Mfg/ Purchased	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
7781 9oz Glass 50"x125yd			No			155	sf	2,302.000	1.0000		10-7-13	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST404	2302	
108932	108	
111166	419	
113905	1775	

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

x12

Purchased

No

155

Each

6,848.000

12.0000

RIVET

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST316	6848	
104374	2848	
110398	4000	

MS20470AD4-5

x18

Purchased

No

155

Each

618.0000

18.0000

Rivet, Universal Head

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST319	618	
111416	618	

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:33:53 PM

Page 12 113

Work Order ID: 57882

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Comments: IPP P 04.02.04 Reformat KJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC


IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Date: 4/19/2010

Start Qty: 1.00

Required Date: 4/26/2010

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining,	Qty	Date	Status
MS21042L08	110	Purchased	No			155	Each	667.0000	10.0000			
<div>8</div>  Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300 400

114330 400

Main Warehouse

ST301 267

114056 67

114227 200

MS21042L3

Purchased

No

155

Each

1,131.000 4.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300 1131

113537 147

113644 984

Monday, April 19, 2010 3:33:53 PM

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:33:53 PM

Page 13 **13**

Work Order ID: 57882



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP P ☐ 04.02.04 ☐ Reformat ☐ KJ/DS ☐
per DS19414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining,	Qty	Date	Status
MS27039-08-11	x2	Purchased	No			155	Each	119.0000	2.0000			
<div style="display: flex; align-items: center;"> 10-7-12 </div>												
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST288	50	
114382	50	
Main Warehouse		
ST290	69	
111977	19	
113749	50	

Monday, April 19, 2010 3:33:53 PM

Shop Packet Print

Page 13

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

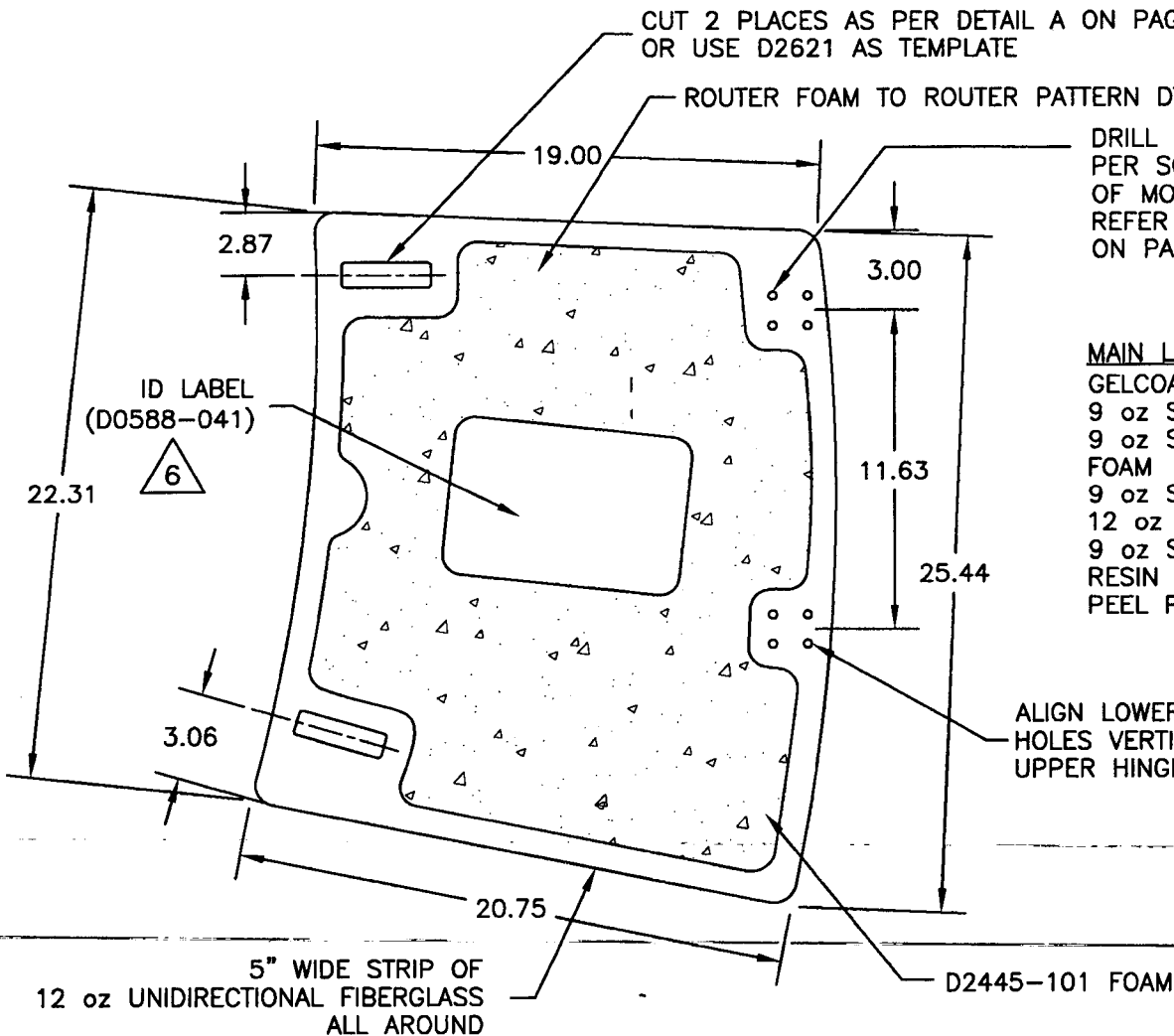
NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]*CUT 2 PLACES AS PER DETAIL A ON PAGE 2
OR USE D2621 AS TEMPLATE

ROUTER FOAM TO ROUTER PATTERN DT8035

DRILL 8 HOLES $\varnothing 0.171$
PER SCRIBE LINES
OF MOLD DT8036 OR
REFER TO DETAIL B
ON PAGE 2**MAIN LAYUP**GELCOAT #GEL 944W005
9 oz SATIN
9 oz SATIN
FOAM
9 oz SATIN
12 oz UNIDIRECTIONAL
9 oz SATIN
RESIN
PEEL PLYALIGN LOWER HINGE
HOLES VERTICALLY WITH
UPPER HINGE HOLES**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYLCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

CL 10/4/20

W10: 57882

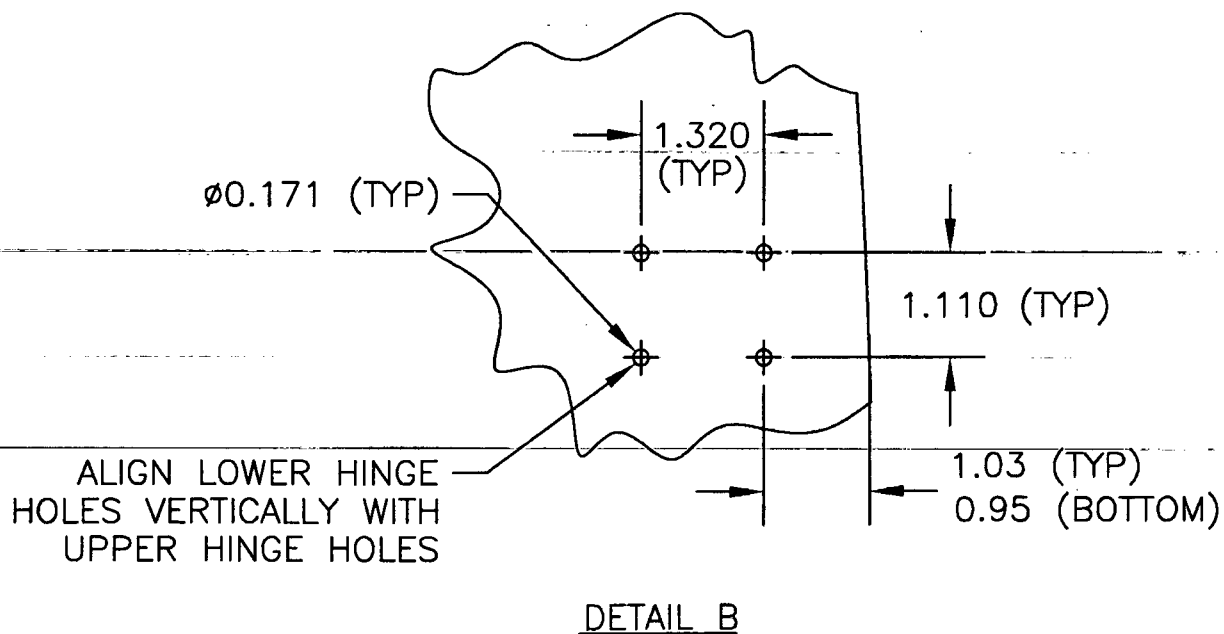
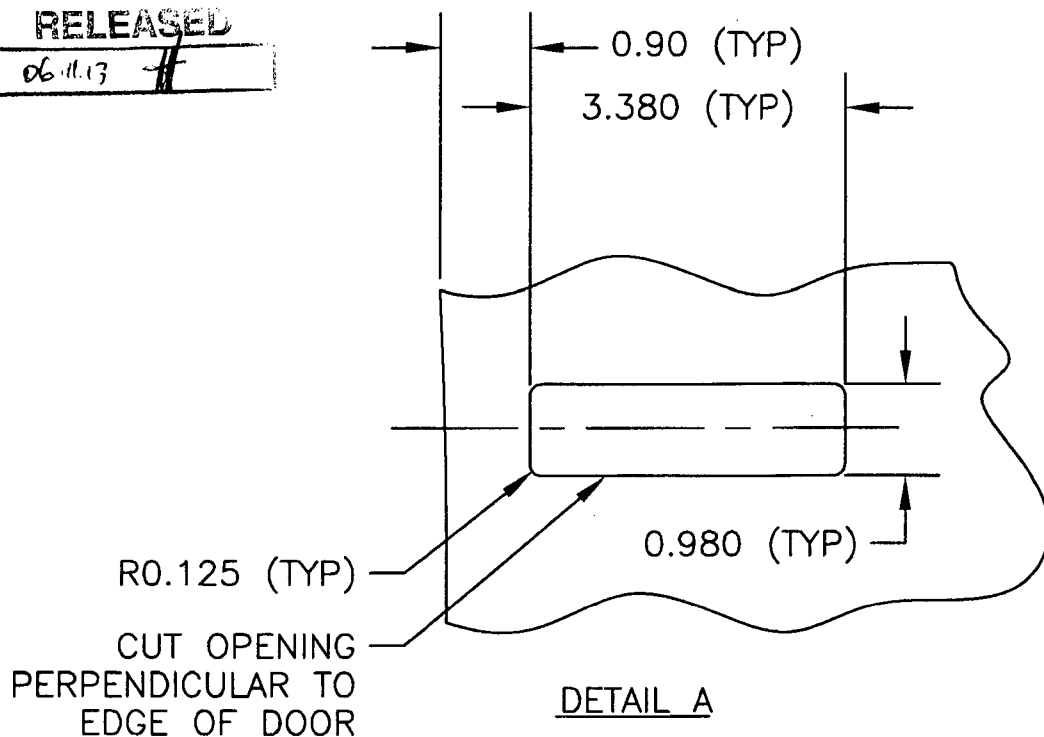
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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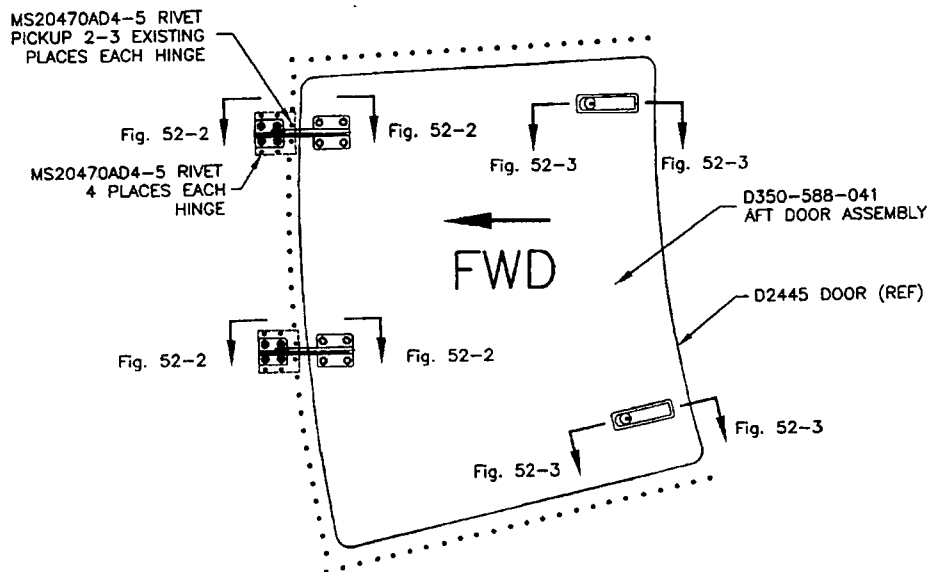


Figure 52-1: Baggage Door Outside View

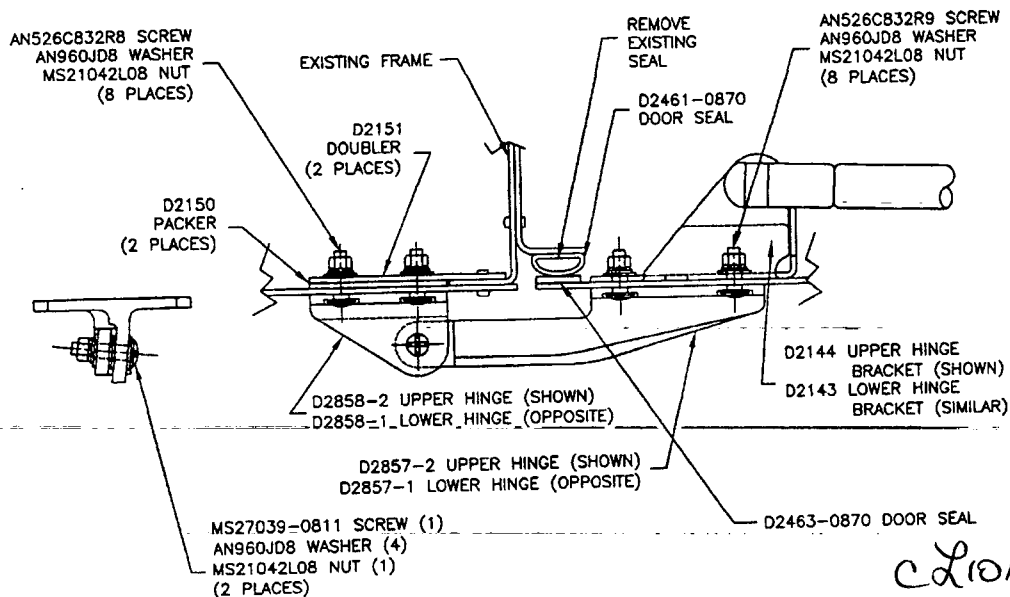


Figure 52-2: Hinge Detail

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52-00-00

Page 3 (4 blank) of 14

Revision: 0

C21014/20
W10.57882

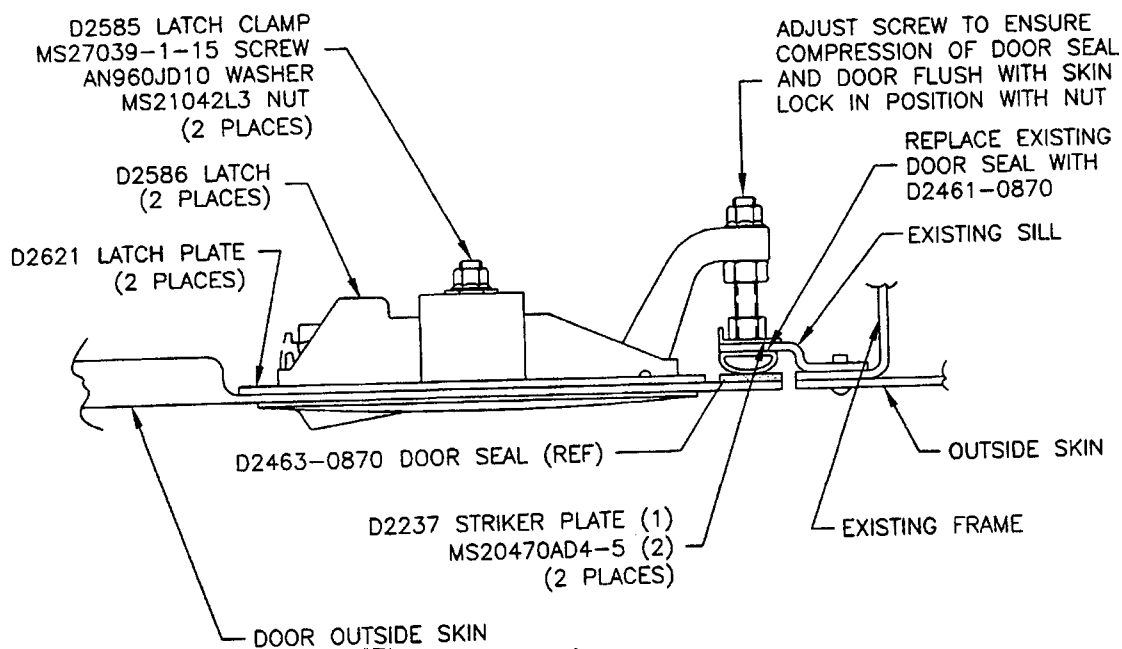


Figure 52-3: Latch Section

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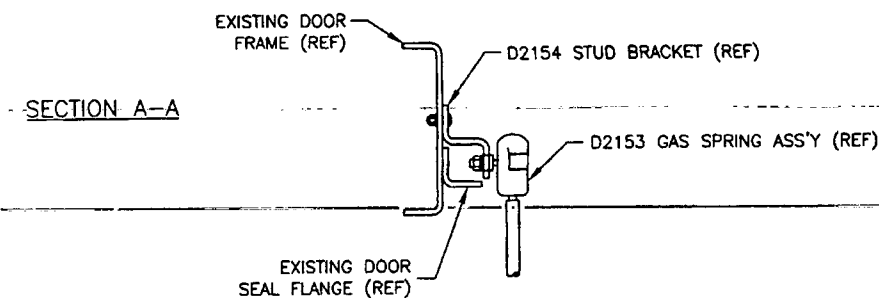
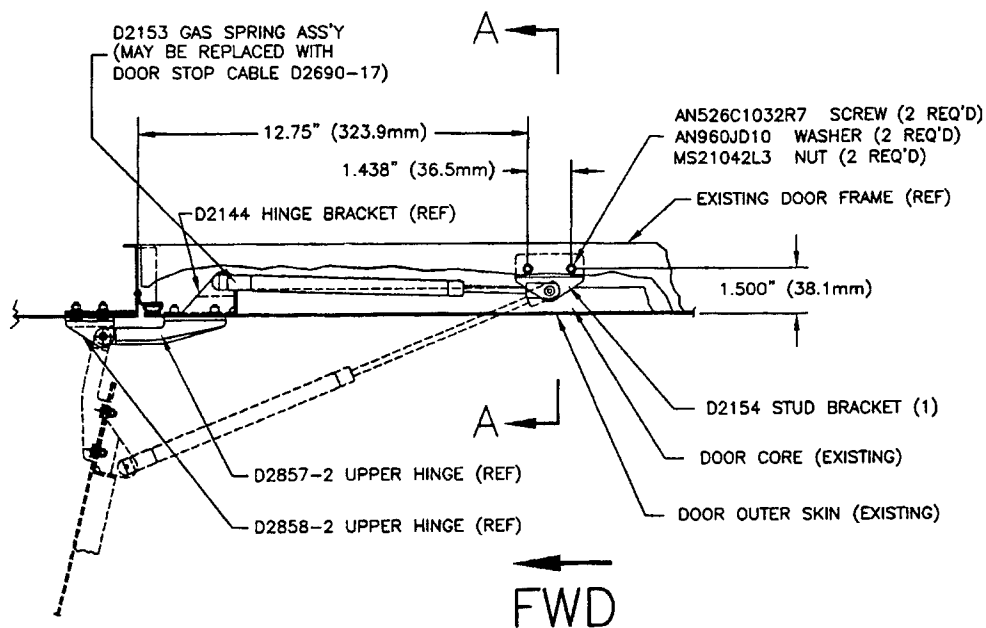


Figure 52-4: Gas Spring Installation

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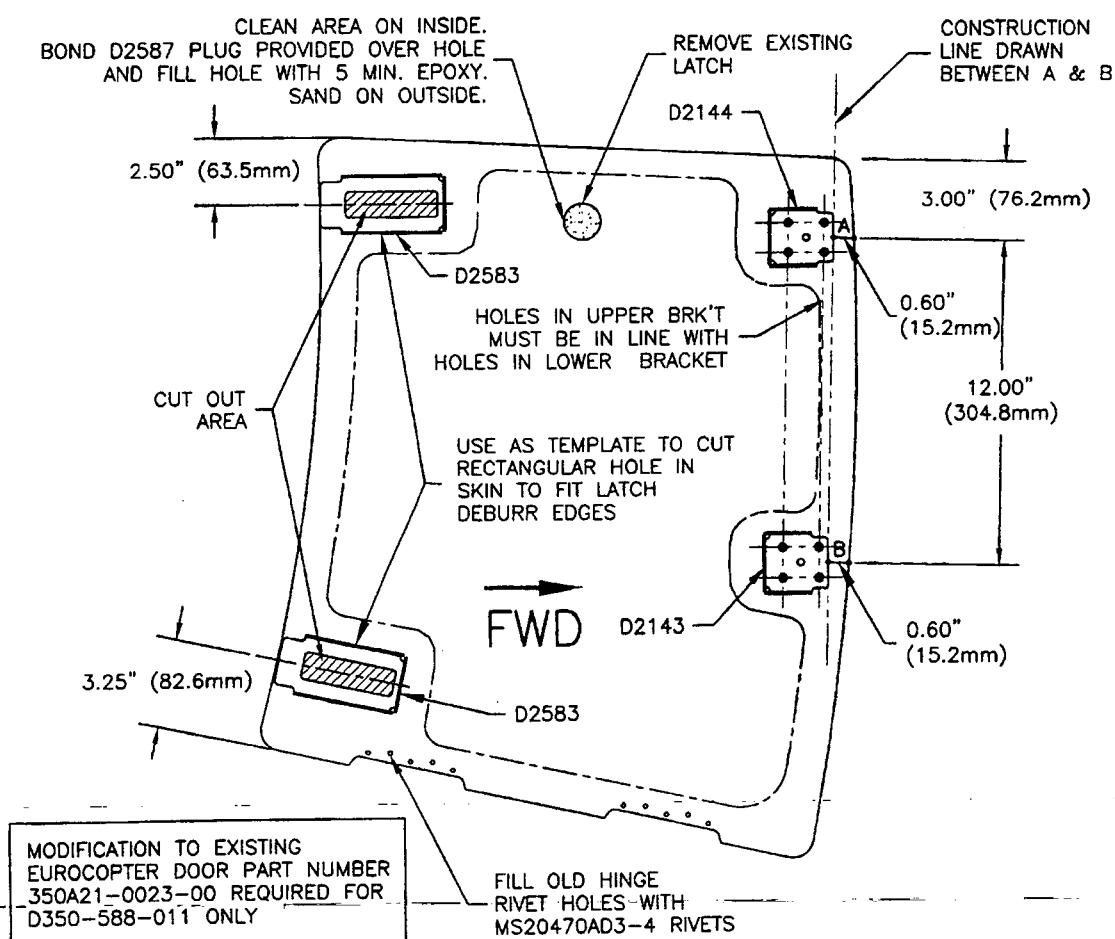


Figure 52-5: Baggage Door Inside View

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52-00-00



Date: Mercredi, 2010-05-12 13:25:58
 Utilisateur: marc dubé

Feuille de Procédé

Client :	DART US DART AEROSPACE LTD	Nom Dessin :	N° D2445, AFT BAGGAGE DOOR
Numéro Job :	26400	Numéro Article :	DKC134-0013
Numéro Soumission :	3959	Numéro Dessin :	D2445
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2010-05-12 No. B.V. :	Révision dessin :	D
Prsht Rev. :	NC	Matériel :	Composite
Prem. fois :	Type :	Date Dûe :	2010-05-19
Job précédente :		Qté:	1 UdM: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Client: D2445		

**Inscrire le N° de
Série : B57882 Sur la
pièce**

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la
 Rév.: 10 de DKC

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0085	FREKOTE 3,78L 44-NC
-----	--------	---------------------

Commentair Qty.: 0.20 UNITE(s)/Unit Total : 0.20 UNITE(s)

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-27406-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

5.0	AC0747	Acetone
-----	--------	---------

Commentair Qty.: 0.130 KILOGRAMME(s)/Unit Total : 0.130 KILOGRAMME(s)

6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 19/05/10 Sceau:  Temps Début: _____ Temps Fin: _____

Date: Mercredi, 2010-05-12 13:25:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26400

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 19/05/10 Sceau:  Temps Début: _____ Temps Fin: _____

8.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

9.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

10.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

11.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

12.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26697-1

13.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

14.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

15.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Mercredi, 2010-05-12 13:25:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26400

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 30/05/10 Heure Début: — Heure Fin: — Sceau:

16.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total : 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

18.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 20/05/10 Heure Début: — Heure Fin: — Sceau:

19.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 20/05/10 Heure Début: — Heure Fin: — Sceau:

20.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 20/05/10 Heure Début: — Heure Fin: — Sceau:

Curing début: 9:05 Curing Fin: 4:25

Date: Mercredi, 2010-05-12 13:25:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26400

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

21.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

22.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27342-1

23.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 5/05/10 Heure Début: — Heure Fin: — Sceau: —



24.0 AAC1611 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)
Polybond B46F N° de Lot: 1-7089-1

25.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: 43653

26.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 27/05/10 Heure Début: — Heure Fin: — Sceau: —



27.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air ambiant pendant 2 heures minimum.

Date: 27/05/10 Heure Début: — Heure Fin: — Sceau: —



Curing Début: 2:40 Curing Fin: 4:20

Date: Mercredi, 2010-05-12 13:25:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26400

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

28.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

29.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27437-1

30.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 28/05/10 Heure Début: — Heure Fin: — Sceau:

31.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 28/05/10 Heure Début: — Heure Fin: — Sceau:

32.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 28/05/10 Heure Début: — Heure Fin: — Sceau:

Curing Début: 11:10 Curing Fin: 9:50

Date: Mercredi, 2010-05-12 13:25:59

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 26400

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

33.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce selon IG 0018

Date: 3/05/10

Heure Début: —

Heure Fin: —

Sceau:



34.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 1/06/10

Heure Début: —

Heure Fin: —

Sceau:



35.0

AAC1605

Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Label N° D0588-041

N° de Lot: 1-27282-1

36.0

AAC1609

Surface Veil

Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)

Surface Veil

N° de Lot: N/A

37.0

AAC1220

Résine Mia-Poxy 100

Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)

Résine Mia-Poxy 100

N° de Lot: 1-25679-2

38.0

AAC1221

Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)

Durcisseur 95 Pour Résine Mia-Poxy

N° de Lot: 1-25679-2

39.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le abel N° D0588-041 selon IG 0111.

Laisser scher pendant 4 heures.

Date: 1/06/10

Heure Début: —

Heure Fin: —

Sceau:



Date: Mercredi, 2010-05-12 13:26:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26400

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Article: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

40.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.025 KIT(s)/Unit Total : 0.025 KIT(s)
MASTIC POLYSOFT SIKKENS 3AR591 N° de Lot: 1-7129-1

41.0 AAC1617 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)
Durcisseur Polysoft #004009 Sikkens N° de Lot: N/A

42.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 11/06/10 Heure Début: _____ Heure Fin: _____ Sceau:

43.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-26575-4

44.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-26575-3

45.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Quantité: 1 Date: 11/06/10 Sceau:

Quantité: 1 Date: 17/06/10 Sceau:

46.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 22-6-10 Heure Début: _____ Heure Fin: _____ Sceau:

47.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Inscrire le N° de
Série : B57882 Sur la
pièce

Date: Mercredi, 2010-05-12 13:26:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 26400

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 22-06-10 Sceau:



Work Order ID 57882

Monday, April 19, 2010 3:33:53 PM

Page 1

Item ID: D350-588-041

Accept

Setup

Start

Revision ID:

Stop

Item Name: Aft Door Assembly

Start Date: 4/19/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00

Customer:

Reference:

Run

Start

Approvals: Process Plan: *CL*

Date: 10/4/20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *11710*
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

REFERENCE ONLY

10-7-01

10-4-20

U

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1	1	D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
2	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
1	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
1	1	D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8) <i>opps. 5012/15</i>
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

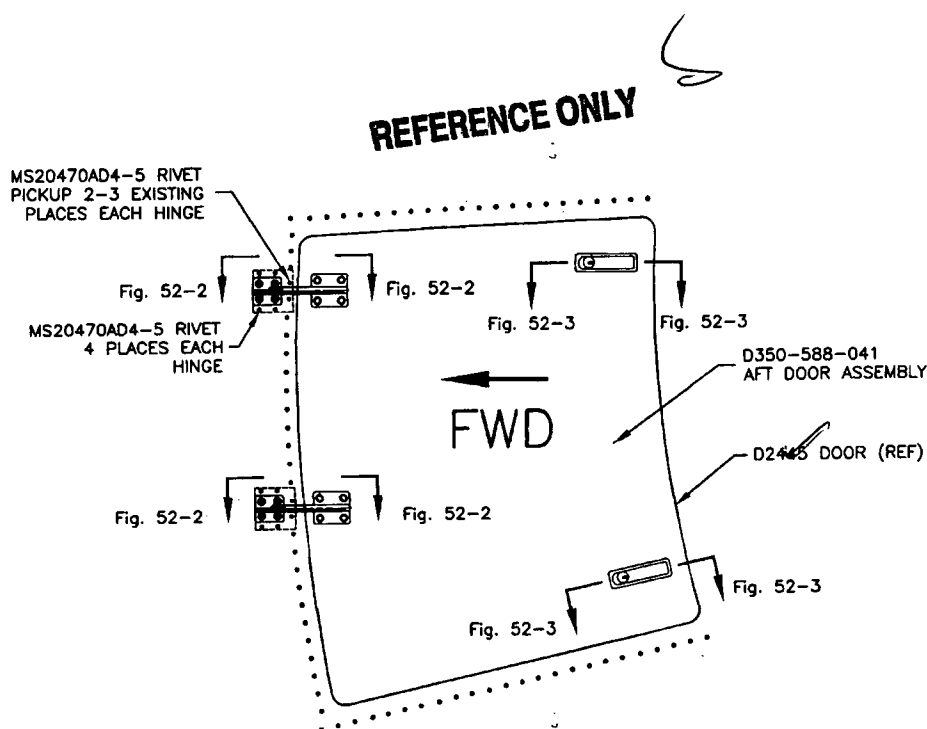


Figure 52-1: Baggage Door Outside View

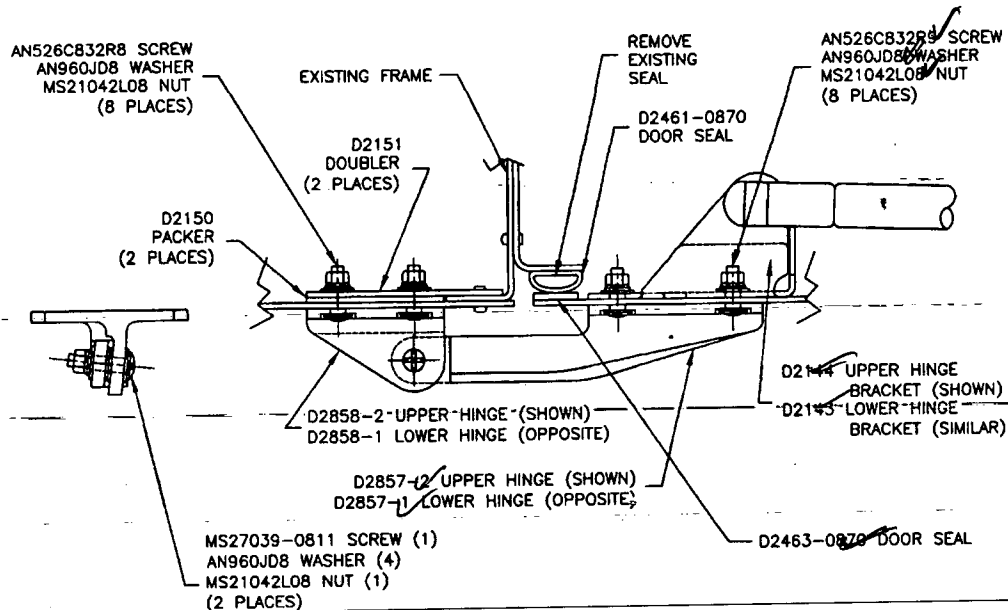
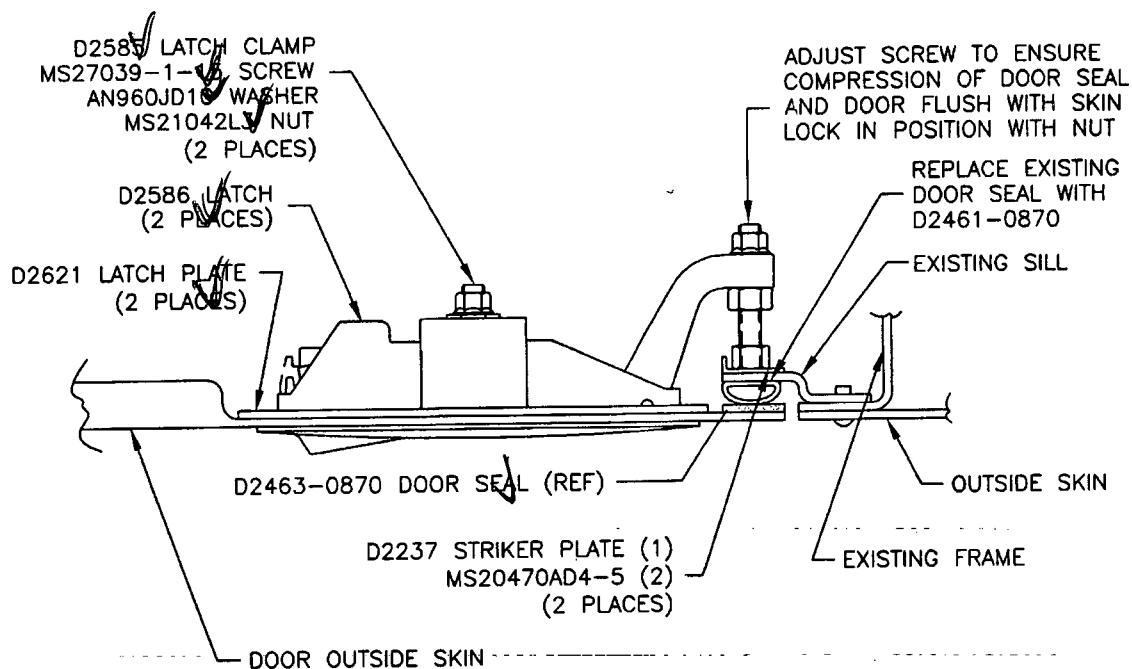


Figure 52-2: Hinge Detail

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REFERENCE ONLY**Figure 52-3: Latch Section**

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